

20-7961



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Canada

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D3121-25

Job Sheet 197880



Part No: D3121-25

Job Qty: 50 pcs

Part Name: Delrin Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 7/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 06-05-10 JLM IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	50 pcs	7/30/19	7/30/19	0.50	2.50	Hardinge - 1		JLD 19/08/19
120	QC 8	50 pcs	7/30/19	7/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		mon 19/08/19
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Packaging 3-1 - Stock - B4B	50 pcs	7/30/19	7/30/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

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P.T.O.

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC
				Packaging 3 - 24 - B4B	St 618
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	50 pcs	7/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - Hardinge -1-Turn D3121-25 Cap as per Folio FA387 Descriptions: 120 - QC8- Inspect parts - second check 130 - Identify as per dwg & Stock Location: 140 - QC21- Final Inspection - Work Order Release)					
AUG 14 2019					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MDELRI1.000	Delrin Round Bar 1" Color: Black	1.6000 ft (.032 ea)	100-Hardinge - 1	578108	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	MDELRI1.000	2	5	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.315inches $\pm$ 0.010	0.325 0.305	0.3180	
2	Cap	1.000inches $\pm$ 0.010	1.010 0.990	0.997	
3	Cap	0.838inches $\pm$ 0.002	0.840 0.836	0.838	
4	Cap	0.063inches $\pm$ 0.010	0.073 0.053	0.069	
5	Cap	0.010inches $\pm$ 0.010	0.020 0.000	0.011	
6	Cap	0.230inches $\pm$ 0.001	0.231 0.229	0.229	PLUS FIT w/BEARER
7	Cap	0.865inches $\pm$ 0.001	0.866 0.864	0.865	

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Entered: ER Date: Feb 14/2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-7961

Route update only ☐

Job: <u>197880</u> Part No: <u>13121-25</u>	DISPOSITION Rework ☒ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
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Date: 19/08/13 Sequence #: 60 QTY Affected: 1 MRB (QSI042) INSP 12 9/12/13

Description Work Order Deviation The ID is under size (.834) of parts	Disposition SCRAP	Completed By <u>gym</u> <u>19/08/13</u> Lead hand / Supervisor <u>JS</u> <u>19-08-13</u> QC / QA Coordinator <u>DAS</u> <u>68</u> <u>9-89</u> <u>AUG 13 2019</u>
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Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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